

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018851**Date Inspected:** 19-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG and Tower Components				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bays 10 and 11

This QA Inspector randomly observed no apparent welding related work in progress in Bays 10 and 11.

OBG Trial Assembly Area

This QA Inspector randomly observed no apparent welding related work in progress in the OBG Trial Assembly Area.

Blast Shop 2

ZPMC requested Caltrans personnel to perform visual inspections of west tower, lift 4 from the bottom end at 114M elevation to the bottom of 131M double diaphragm. At approximately 2230 hours to 2330 hours, following the initial blast cleaning of the steel surfaces, several QA Inspectors, including this QA Inspector, performed random visual inspections of these areas. ABF and ZPMC Inspectors were present and performing visual inspections of the areas noted above. ABF Representative Xiao Jun Peng (BABF) and ZPMC QC Sun Zi Wang (BQC) informed this QA Inspector that they would be documenting all weld repairs and would provide this to the QA Inspectors with a copy of the documentation. This QA Inspector visually observed several areas that required grinding to resolve visual weld spatter, arc strikes, shallow nicks, scrapes, rough edges of unground welds, and sharp edges of ground welds. These areas were clearly marked with chalk as either "grind" or "grind and perform

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

magnetic particle testing (MT)” using the letter G or the letters G+MT, respectively. This QA Inspector was notified that the above noted areas had been ground and MT had been performed. This QA Inspector randomly visually verified that the work had been performed. Weld repairs were observed by other inspectors. All locations were documented by BQC and BABF. A copy of the documentation was presented to the QA Inspectors.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
